

Work Order ID 58342

Monday, May 03, 2010 2:58:10 PM



Page 1

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *mf*

Date: 10-5-3

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3909

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EP 10/05/11 (6)

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
Trim rivet to 1.185" long

EP 10/05/11 (6)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. Wolby

(46)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Page 2

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 506

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
10-5-12

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NOTE: Date & initial all entries

Picklist Print

Monday, May 03, 2010 2:58:10 PM

Page 1

Work Order ID: 58342

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Comments: IPP RevA: New issue DD verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Date: 5/10/2010

Required Date: 5/14/2010

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| D2690-6 Lanyard Assembly | | Manufactured | No | | | 100 | Each | 5.0000 | 1 | | | |

Location Loc Qty Loc Code
ST021 5

50665 5

D3909-1 Manufactured No

100 Each 6.0000

Lug Plate, Fwd Crosstube

Location Loc Qty Loc Code
ENG 2

55704 2

ST095 4

57824 4

D3909-3 Manufactured No

100 Each 2.0000

Fwd Lower Attach Arm

Location Loc Qty Loc Code
ST095 2

56952 2

D3909-5 Manufactured No

100 Each 0.0000

Eyebolt Stud

D3910-1 Manufactured No

100 Each 12.0000

Crosstube Lug

Location Loc Qty Loc Code
ENG 12

57194 12

450/05/11
358375 (X)

4510/05/11
2

4510/05/11
358340 (X)

4510/05/11
358240 (X)

4510/05/11

358341 (X)

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|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|

D3917-1

Manufactured

No

100

Each

74.0000

2



Washer

Location

Loc Qty

Loc Code

ST065

40

57821

40

ST096

34

57830

34

AN3C12A

Purchased

No

100

Each

176.0000

4



Bolts

Location

Loc Qty

Loc Code

ST351

176

112314

176

AN3C13

Purchased

No

100

Each

38.0000

1



Bolt

Location

Loc Qty

Loc Code

ST351

38

114304

38

MS17984-C413

Purchased

No

100

Each

27.0000

1



PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST297

4

114340

4

ST314

23

114495

3

114523

20

Monday, May 03, 2010 2:58:10 PM

Shop Packet Print

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Picklist Print

Page 3

Monday, May 03, 2010 2:58:10 PM

Work Order ID: 58342



Parent Item: D3909-041



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Start Date: 5/10/2010

Required Date: 5/14/2010

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|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| MS20615-4M2018 | | Purchased | No | | | 100 | Each | 204.0000 | 3 | | | |



RIVET

M114506 (18)

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST323 | 204 | |
| 113254 | 16 | |
| 114324 | 4 | |
| 114349 | 184 | |

EP 5/10/05/11

| | | | | | | | | | | | |
|---------|-----------|----|--|--|-----|------|---------|---|--|--|--|
| AN310C3 | Purchased | No | | | 100 | Each | 38.0000 | 1 | | | |
|---------|-----------|----|--|--|-----|------|---------|---|--|--|--|



Castellated Nut

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST349 | 38 | |
| 114304 | 38 | |

EP 5/10/05/11

| | | | | | | | | | | | |
|-----------|-----------|----|--|--|-----|------|-----------|---|--|--|--|
| MS21043-3 | Purchased | No | | | 100 | Each | 3,735.000 | 4 | | | |
|-----------|-----------|----|--|--|-----|------|-----------|---|--|--|--|



Nut

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FG | 80 | |
| 103691 | 80 | |
| ST301 | 3655 | |
| 112314 | 3655 | |

EP 5/10/05/11

| | | | | | | | | | | | |
|-------------|-----------|----|--|--|-----|------|----------|---|--|--|--|
| MS24665-151 | Purchased | No | | | 100 | Each | 701.0000 | 1 | | | |
|-------------|-----------|----|--|--|-----|------|----------|---|--|--|--|



Cotter Pin

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST309 | 701 | |
| 17566 | 701 | |

EP 5/10/05/11

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Shop Packet Print

Page 3

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Work Order ID: 58342

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 5/10/2010



Required Date: 5/14/2010

Comments: IPP RevA: New issue DD verified by:EC
per dwg revB DD 10.04.20 verified by:EC

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Start Qty: 6.00

Required Qty: 6.00

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|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|---------------|----------------|--------|
| NAS1149C0332R | | Purchased | No | | | 100 | Each | 3,848.000 | 8 | | | |
| <div>  </div> | | | | | | | | | | | | |
| Washer | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | ST297 | | 3848 | | | | | | |
| | | | | | 113524 | 10 | | | | | | |
| | | | | | 113737 | 150 | | | | | | |
| | | | | | 114341 | 3688 | | | | | | |
| NAS1149C0363R | | Purchased | No | | | 100 | Each | 1,199.000 | 2 | | | |
| <div>  </div> | | | | | | | | | | | | |
| Washer | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | ST297 | | 1199 | | | | | | |
| | | | | | 113422 | 35 | | | | | | |
| | | | | | 113524 | 464 | | | | | | |
| | | | | | 113644 | 200 | | | | | | |
| | | | | | 113889 | 500 | | | | | | |

EP 5/10/05/11

48
EP 5/10/05/11

12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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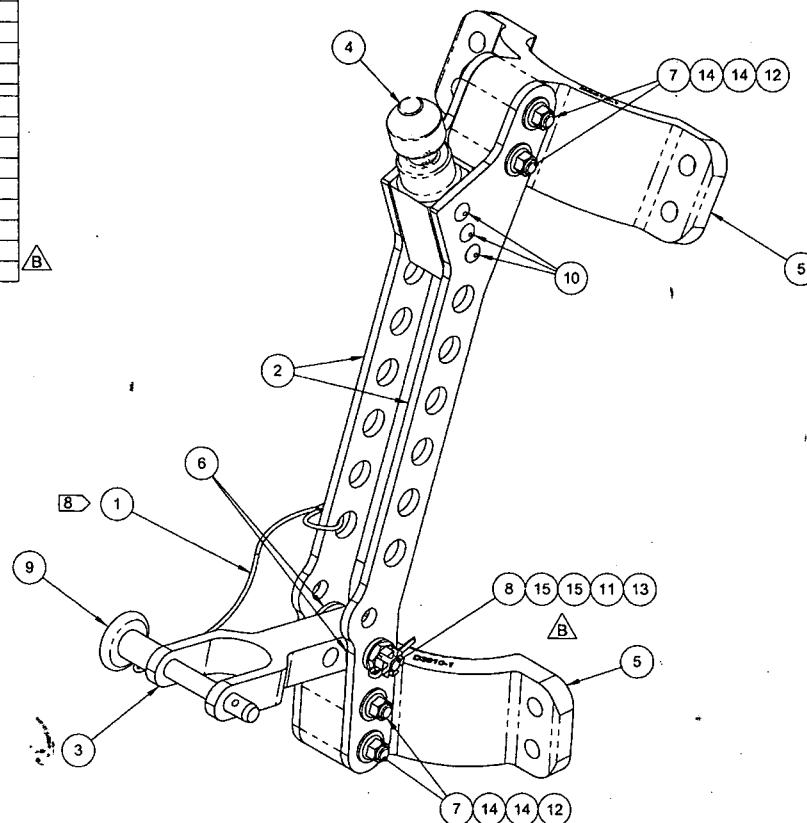
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|----------------------|
| | X | D3909-041 | FWD X-TUBE LUG ASSY |
| 1 | 1 | D2690-6 | LANYARD |
| 2 | 2 | D3909-1 | FWD X-TUBE LUG PLATE |
| 3 | 1 | D3909-3 | FWD LOWER ATTACH ARM |
| 4 | 1 | D3909-5 | EYEBOLT STUD |
| 5 | 2 | D3910-1 | X-TUBE LUG |
| 6 | 2 | D3917-1 | WASHER |
| 7 | 4 | AN3C12A | BOLT |
| 8 | 1 | AN3C13 | BOLT |
| 9 | 1 | MS17984-C413 | PIP PIN |
| 10 | 3 | MS20615-4M20 | RIVET |
| 11 | 1 | AN310C3 | NUT - CASTELLATED |
| 12 | 4 | MS21043-3 | NUT |
| 13 | 1 | MS24665-151 | COTTER PIN |
| 14 | 8 | NAS1149C0332R | WASHER |
| 15 | 2 | NAS1149C0363R | WASHER |



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.74 lbs
- 8) ATTACH TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

RELEASED
2010-04-07

| | | | |
|------------|---|--|--------------|
| B | BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED: SECTION A-A & DIM Ø0.650 REMOVED, SIDE VIEW ADDED, DIM: 2.68 WAS 2.38 REF: 1.30 WAS 1.00, 0.250 WAS D.220, R0.06 WAS R0.05, WEIGHT REVISED. | JPH | 10.04.06 |
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | JPH | DRAWING NO. | REV. B |
| MFG. APPR. | | D3909 | SHEET 1 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FWD X-TUBE LUG ASSY | NTS |
| DATE | 10.04.06 | COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

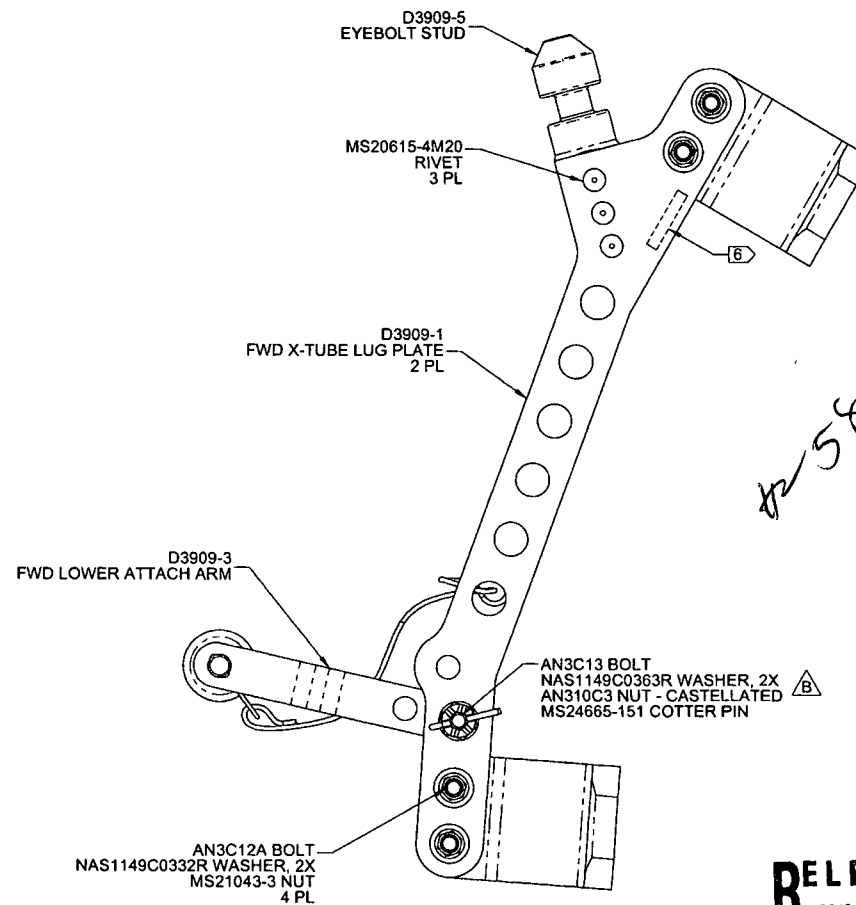
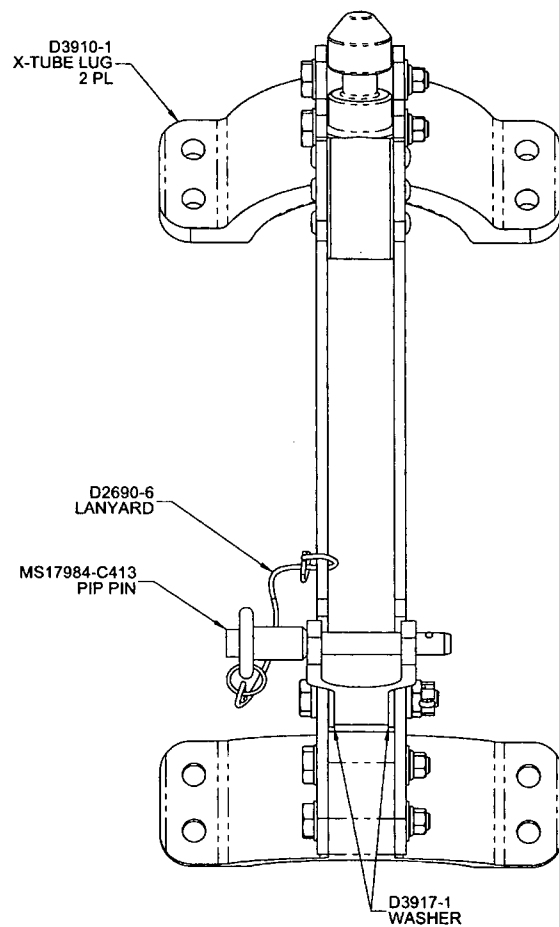
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NOTE: Date & initial all entries



D3909-041 FWD X-TUBE LUG ASSY

RELEASED
2010-04-07
mp

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D3909 | REV. B |
| MFG. APPR. | <i>[Signature]</i> | TITLE FWD X-TUBE LUG ASSY | SHEET 2 OF 5 |
| APPROVED | <i>[Signature]</i> | SCALE NTS | |
| DE APPR. | <i>[Signature]</i> | <small> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small> | |
| DATE | 10.04.06 | | |

Dart Aerospace Ltd

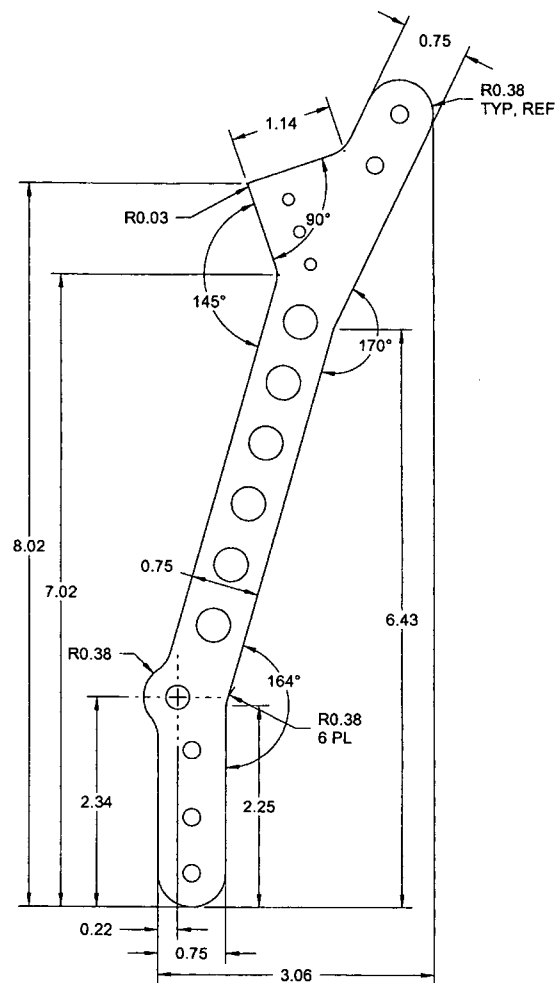
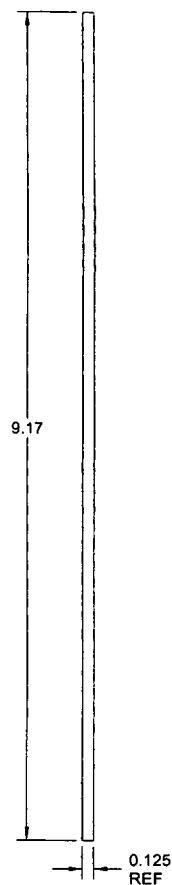
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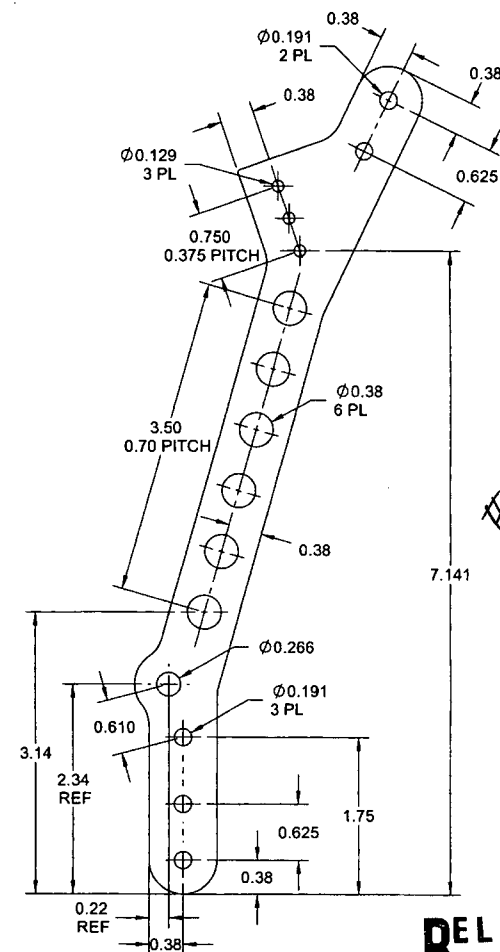
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NOTE: Date & initial all entries



D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.25 lbs

RELEASED
2010-04-07
WPH

| | | | |
|------------|--------------------|--|--------|
| DESIGN | JPH | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D3909 | REV. B |
| MFG. APPR. | <i>[Signature]</i> | SHEET 3 OF 5 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FWD X-TUBE LUG ASSY | NTS |
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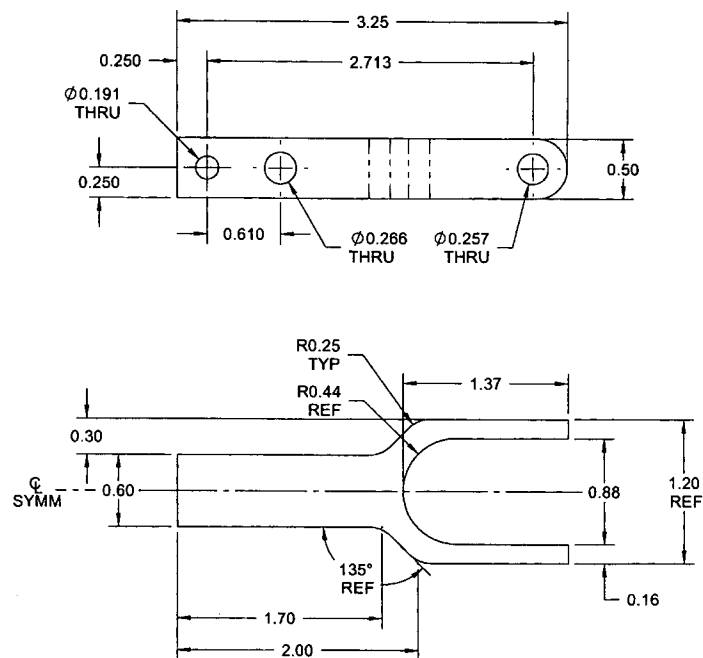
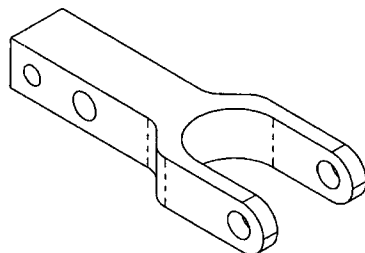
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3909-3 FWD LOWER ATTACH ARM

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

RELEASED
2010-04-07

| | | | |
|------------|----------|--|--------------|
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | JPH | DRAWING NO. D3909 | REV. B |
| MFG. APPR. | | TITLE FWD X-TUBE LUG ASSY | SHEET 4 OF 5 |
| APPROVED | | SCALE | NTS |
| DE APPR. | | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 10.04.06 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

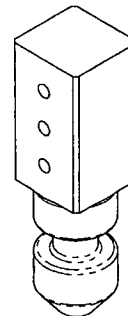
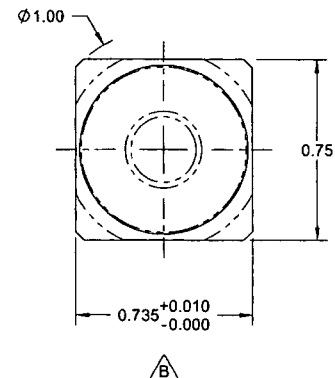
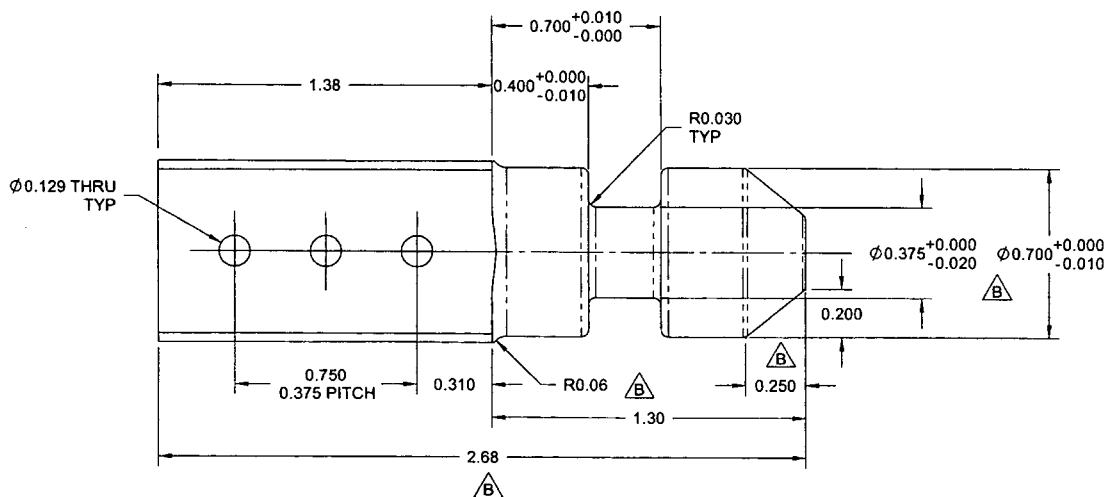
8 7 6 5 4 3 2 1

D

C

B

A



#58342

D3909-5 EYEBOLT STUD

RELEASED
2010-04-07
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | JPH | DRAWING NO. D3909 | REV. B |
| MFG. APPR. | | | SHEET 5 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FWD X-TUBE LUG ASSY | NTS |
| DATE | 10.04.06 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

8 7 6 5 4 3 2 1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries